

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79333

January-24-12 4:24:43 PM

79333

Page 2

Item ID: D2327-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer Bushing
Start Date: 24/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 30/01/2012 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location <u>ST WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

25X SP 12-02-10

M.L.J 12/02/15

M.L.J 12/02/15
(25)

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Picklist Print

January-24-12 4:24:52 PM

Page 1

Work Order ID: 79333

79333

Parent Item: D2327-3

D2327-3

Parent Item Name: Spacer Bushing

Start Date: 24/01/2012

Required Date: 30/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP F05.11.02Removed 303 SSKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	44.8140	0.1563	3.290526			

M304R0.375

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT029

44.814

→ 119346

20.714

120204

24.1

4.2 on 12/02/10

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DART AEROSPACE LTD		Work Order:	79333
Description: Spacer Bushing		Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	Ø.3745	—		Vern MLC	
Ø0.257	+0.005/-0.000	Ø.257	—			
1.750	+/-0.010	1.753	—			

Measured by:	<i>ML</i>	Audited by:	<i>SL</i>	Prototype Approval:	N/A
Date:	12/02/10	Date:	12-02-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	<i>JD</i>

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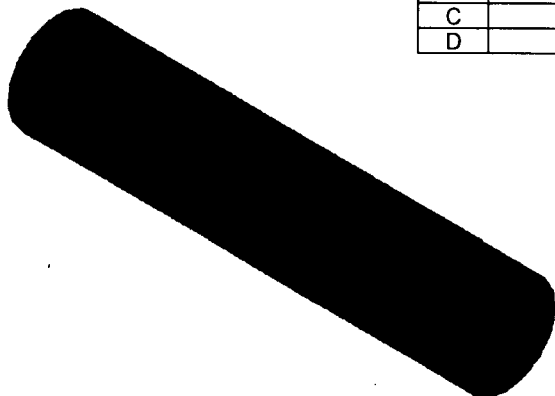
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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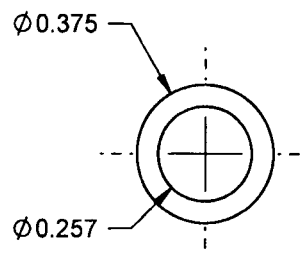
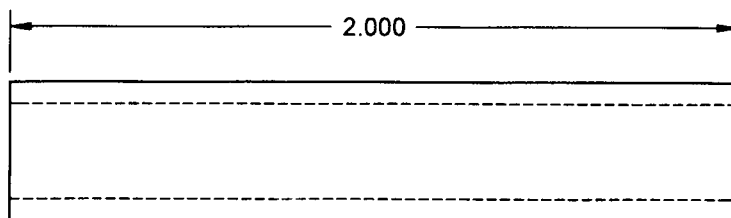
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12	TITLE SPACER BUSHING		SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



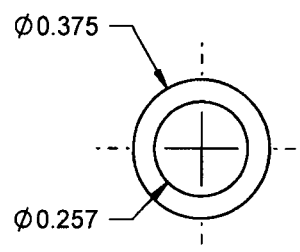
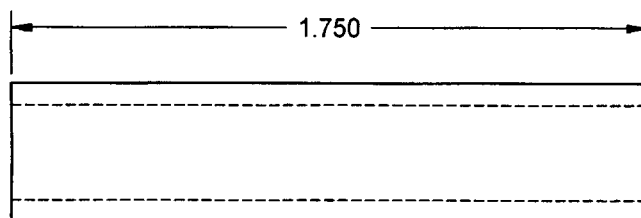
RELEASED

06.11.14 [Signature]

SHOP COPY
RETURNED
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 79333 M.L.J
12101124



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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